ABSTRACT

The present invention is directed to a method and apparatus for startup of extruded film tubes. A controller member is utilized to provide control signals to a supply blower which supplies air to the extruded film tube in an amount corresponding to a supply control signal, and an exhaust blower which exhausts air from the extruded film tube in an amount corresponding to an exhaust control signal. The controller member executes program instructions which define at least one control routine for automatic and coordinated control of the supply blower and the exhaust blower during starting of the extruded film tube, by directing a series of supply control signals to the supply blower and exhaust control signals to the exhaust blower. When a valve is utilized to control the flow of air from the supply blower to the extruded film tube, the controller is also utilized to adjust the supply blower and the exhaust blower in order to optimize operation of the valve by placing the valve in a substantially linear operating range. Additionally, the controller member may be utilized to execute program instructions in order to implement a bubble break detection routine which utilizes software timers in combination with monitoring of a position signal in order to determine collapse or break of the extruded film tube.